

Work Order ID 87027

87027

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July-10-12 7:08:37 AM

Item ID: D412-742-013 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Float Skidtube Installation
 Start Date: 7/10/12 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 8/03/12 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
IIN D412-742	E								
100		0.00							
100		DOCUMENT CONTROL							
DC		Memo							
Document Control		Photocopy bluefile and create labels per PPP D412-742-013	CHG007						
110		0.00							
110		Pick Kit							
Packaging		Memo							
Packaging									
120		0.00							
120		QC4- 100% Inspect kits for completeness							
QC		Memo							
Quality Control									

DAS 16 12/6/12 JB

12-7-10

12/07/11 JB

DAS 16 12/6/12

40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 87027

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Item ID: D412-742-013 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Float Skidtube Installation
Start Date: 7/10/12 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 8/03/12 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-742-013								
	Location: 73								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

U 120730

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 87027
 Parent Item: D412-742-013
 Parent Item Name: Float Skidtube Installation

Start Date: 7/10/12
 Start Qty: 1.00
 Required Date: 8/03/12
 Required Qty: 1.00

Comments: IPP Rev: A05.10.13New Issue KJ/JLM
 IPP Rev:B 06-06-08 As per DSI9336 JLM 1072 DD verified by:JLM
 IPP Rev:D 08-09-08 ecn 08-510 DD verified by:EC
 IPP Rev:E 09-01-23 as per DSI9441 DD verified by:EC IPP RevF: add AN4C7A DD 10.01.13 verified by:EC
 IPP Rev:G 11.11.01 as per DSI9517 REV.B DD verified by:EC IPP rev:H 12.01.12 PER IIN REV.E DD VERF: DD 12.03.14 verified by:EC
 IPP RevC 07-12-03 ECN IPP Rev:I add AN4C47A

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4C47A Bolt		Purchased	No			110	Each	128.0000	4	4			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST361		128							
				118451		6							
				119798		2							
				121009		22							
				121585		2							
				122012		46		122012					
				122204		50							
D412-742-043 Replacement Float Skidtube		Manufactured	No			110	Each	0.0000	1	1			
D2571 Saddle, Fwd Out 205		Manufactured	No			110	Each	7.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST		1							
				11644		1							
				ST425		-13							
				ST432		6							
				85883		6		85883					
				ST433		13							

8/10/12
 8/10/12

852528
 JB 12/07/11

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 87027

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 7/10/12

Required Date: 8/03/12

Start Qty: 1.00

Required Qty: 1.00

D2572
Saddle, Fwd In 205

Manufactured No

110 Each 7.0000

0 85608 1 JB L

Location Loc Qty Loc Code

ST432 7

71107 2

85882 5

D2573
Saddle, Aft Out 205

Manufactured No

110 Each 3.0000

1 1 JB L

Location Loc Qty Loc Code

ST423 -12

79424 0

ST433 3

83669 3

ST434 12

83669

D2574
Saddle, Aft In 205

Manufactured No

110 Each 3.0000

1 1 JB L

Location Loc Qty Loc Code

ST433 3

83671 3

D2876
Saddle Spacer

Manufactured No

110 Each 94.0000

2 2 JB L

Location Loc Qty Loc Code

ST020 94

83323 40

83890 54

D2877
Saddle Spacer

Manufactured No

110 Each 64.0000

2 2 JB 12/07/11 L

Location Loc Qty Loc Code

ST020 64

83324 3

83891 61

83891

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 87027

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 7/10/12

Required Date: 8/03/12

Start Qty: 1.00

Required Qty: 1.00

D3403-1 Bushing Manufactured No 110 Each 65.0000 8 8 JB

Location	Loc Qty	Loc Code
ST041	15	
70696	15	
ST042	50	
80208	7	
80219	4	
85661	39	

D3403-5 Bushing Manufactured No 110 Each 45.0000 8 8 JB

Location	Loc Qty	Loc Code
ST042	45	
85664	45	

D2747 Set Screw Manufactured No 110 Each 96.0000 4 4 JB

Location	Loc Qty	Loc Code
ST017	96	
79520	5	
81877	91	

D3533-1 Set Screw Manufactured No 110 Each 68.0000 2 2 JB 12/07/10

Location	Loc Qty	Loc Code
ST053	68	
80326	2	
83892	66	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 87027

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 7/10/12

Required Date: 8/03/12

Start Qty: 1.00

Required Qty: 1.00

AN4G6A Bolt	Purchased	No	110	Each	423.0000	16	16	JB	
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			FG	4					
			103344	4					
			ST356	419					
			116704	2					
			120423	1					
			121657	416		121657			
AN4G53A Bolt	Purchased	No	110	Each	105.0000	4	4	JB	
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST361	105					
			122193	99		2x 122193			
			122194	6		2x 122194			
AN4G52A BOLT	Purchased	No	110	Each	8.0000	4	4	122518 JB	
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST361	8					
			117688	6					
			120364	2					
AN6G12A BOLT	Purchased	No	110	Each	48.0000	8	8	JB	
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST341	48					
			121541	7					
			122204	41		122204			
D3672-3 Phenolic Washer	Manufactured	No	110	Each	811.0000	32	32	JB 12/07/10	
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST060	811					
			84361	311		84361			
			84432	500					

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Work Order ID: 87027

Parent Item: D412-742-013

Start Date: 7/10/12

Required Date: 8/03/12

Parent Item Name: Float Skidtube Installation

Start Qty: 1.00

Required Qty: 1.00

AN960G416L WASHER Purchased No

110 Each 0.0000

32 121255 32 JB C

D3672-9 Phenolic Washer Manufactured No

110 Each 308.0000

8 8 JB C

Location

Loc Qty

Loc Code

ST060

308

81763

308

81763

AN960G416L WASHER Purchased No

110 Each 183.0000

8 8 JB C

Location

Loc Qty

Loc Code

ST297

183

119736

2

120308

1

121825

180

121825

D3672-11 Phenolic Washer Manufactured No

110 Each 203.0000

8 8 JB C

Location

Loc Qty

Loc Code

ST060

203

77483

203

27483

MS21043-4 Nut Purchased No

110 Each 1,779.0000

29 29 JB 12/07/10 C

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

739

119546

4

121162

295

121652

440

ST318

1000

122141

1000

121162

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 87027

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 7/10/12

Required Date: 8/03/12

Start Qty: 1.00

Required Qty: 1.00

D3403-3 Bushing Manufactured No 110 Each 52.0000 **8** 8 JB h

Location Loc Qty Loc Code

ST042 52

85662 52

D3405-041 Lug Assembly Manufactured No 110 Each 13.0000 **1** 1 JB h

Location Loc Qty Loc Code

ST478 13

62227 2

77000 2

83370 3

83896 6

D3405-043 Lug Assembly Manufactured No 110 Each 8.0000 **1** 1 JB h

Location Loc Qty Loc Code

ST478 8

82038 1

83897 7

AN4G7A Bolt Purchased No 110 Each 123.0000 **4** 4 JB c

Location Loc Qty Loc Code

ST356 123

109147 123

D3407-041 Tow Ring Manufactured No 110 Each 2.0000 **1** 1 JB h

Location Loc Qty Loc Code

ST463 2

82068 2

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 87027

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 7/10/12

Required Date: 8/03/12

Start Qty: 1.00

Required Qty: 1.00

D3417-3 Washer Manufactured No 110 Each 21.0000 2 2 ✓ JB C

Location Loc Qty Loc Code

FG 9

33519 9

ST042 12

80225 12

D3456-1 Washer Manufactured No 110 Each 215.0000 0 1 ✓ JB C

Location Loc Qty Loc Code

FG 7

25701 7

ST044 208

80252 1

81876 15

83584 92

85223 100

AN3C37A BOLT Purchased No 110 Each 154.0000 1 1 ✓ JB C

Location Loc Qty Loc Code

ST324 50

122204 50

ST354 104

116874 11

117010 2

120422 3

121068 36

121584 2

121585 50

AN3C40A BOLT Purchased No 110 Each 20.0000 1 1 ✓ JB 12/07/12 C

Location Loc Qty Loc Code

ST354 20

114442 20

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 87027

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 7/10/12

Required Date: 8/03/12

Start Qty: 1.00

Required Qty: 1.00

AN3C41A
BOLT

Purchased No

110 Each 211.0000

U 1 JB

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	4	
103324	4	
ST354	207	121013
121013	26	
121313	80	
121689	1	
122241	100	

AN3C42A
BOLT

Purchased No

110 Each 69.0000

0 1 JB

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST354	69	
106176	1	
120464	1	
121103	17	121103
122241	50	

AN3C43A
BOLT

Purchased No

110 Each 61.0000

4 4 JB

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST354	61	
114455	2	
119673	1	
120465	58	120465

AN3C46A
BOLT

Purchased No

110 Each 51.0000

5 5 JB 12/07/10

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST355	51	
120447	3	
122204	48	122204

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 87027

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 7/10/12

Required Date: 8/03/12

Start Qty: 1.00

Required Qty: 1.00

AN960C10L washer Purchased No

NAS1149C0332R

110 Each 21.0000

26

26

122063 25

Location

Loc Qty

Loc Code

ST 21

107534 21

MS21043-3 Nut Purchased No

110 Each 1,096.0000

13

13

JB 12/07/10

Location

Loc Qty

Loc Code

FG 72

103691 72

ST301 1024

118077 2

118614 12

118686 30

119758 20

121255 103

121708 857

121255

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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5.2 D412-742-013 (APICAL TRI-BAG) Float Skidtube Installation Parts List

Item	Qty -013	Qty -043	Part Number	Description
	X		D412-742-013	FLOAT SKIDTUBE INSTALLATION
	X	X	D412-742-043	FLOAT SKIDTUBE
		1	D3391-043	412 FLOAT SKIDTUBE
1		*24	*AN3C4A	*BOLT
3		*10	*AN3C6A	*BOLT
4		*4	*AN3C7A	*BOLT
5		*38	*AN960C10L	*WASHER
21		*1	*D4095-041	*WEARSHOE (REPLACES D3564-1)
22		*1	*D4095-043	*WEARSHOE (REPLACES D3564-3)
23		*1	*D4095-045	*WEARSHOE (REPLACES D3564-5)
10		*1	*D3391-021	*412 FORWARD TUBE
11		**1	**D3401-041	**TOW CAP
12A		**10	**AELS-1032-225	**INSERT (REPLACES NAS1330S3KB166)
13		**10	**AN3C4A	**BOLT
14A		**4	**D3672-1	**WASHER (REPLACES NAS1515H3L)
14B		**10	**AN960C10L	**WASHER
24		**1	**D4095-051	**WEARSHOE (REPLACES D3564-13)
20		*1	*D3391-023	*412 MID TUBE
28		**20	**AELS-1032-130	**INSERT (REPLACES NAS1330S3KB116)
30		*1	*D3391-025	*412 AFT TUBE
25		**1	*D4095-049	**WEARPAD (REPLACES D3537-1)
26		**1	*D4095-047	**WEARPAD (REPLACES D3537-7)
31		**1	**D2646	**AFT CAP
32		**14	**AELS-1032-130	**INSERT
36		**8	**AELS-1032-225	**INSERT (REPLACES NAS1330S3KB366)
37A		**6	**AN3C4A	**BOLT
37B		**4	**AN3C5A	**BOLT
38A		**2	**D3672-1	**WASHER (REPLACES NAS1515H3L)
38B		**10	**AN960C10L	**WASHER

(CONTINUED ON PAGE 20)

(CONTINUED FROM PAGE 19)

Item	Qty -013	Qty -043	Part Number	Description
40	1		D2571	SADDLE, FWD OUTSIDE
41	1		D2572	SADDLE, FWD INSIDE
42	1		D2573	SADDLE, AFT OUTSIDE
43	1		D2574	SADDLE, AFT INSIDE
44	2		D2876	SADDLE SPACER
45	2		D2877	SADDLE SPACER
46A	8		D3403-1	BUSHING
46B	8		D3403-5	BUSHING
47A	4		D2747	SET SCREW
47B	2		D3533-1	SET SCREW
48	16		AN4C6A	BOLT
49A	4		AN4C52A	BOLT
49B	4		AN4C53A	BOLT
50	8		AN6C12A	BOLT
51A	32		D3672-3	WASHER (REPLACES NAS1515H4L)
51B	32		AN960C416L	WASHER
52A	8		D3672-9	WASHER (REPLACES NAS1515H6L)
52B	8		AN960C616L	WASHER
53	8		D3672-11	WASHER (REPLACES NAS1515H7L)
54	24		MS21043-4	NUT
55	4		AN4C7A	BOLT
56	2		D3591-1	BUSHING
60	8		D3403-3	BUSHING
61	1		D3405-041	GHW LUG
62	1		D3405-043	GHW LUG
63	4		AN4C47A	BOLT
64	4		MS21043-4	NUT
70	1		D3407-041	TOW RING
71	2		D3417-3	WASHER
72	1		MS21043-4	NUT
73	1		D3456-1	WASHER
91	1		AN3C37A	BOLT
92	1		AN3C40A	BOLT
93	1		AN3C41A	BOLT
94	1		AN3C42A	BOLT
95	4		AN3C43A	BOLT
97	5		AN3C46A	BOLT
99	26		AN960C10L	WASHER
100	13		MS21043-3	NUT

*DENOTES PART IS INCLUDED WITH D3391-043 ASSEMBLY ABOVE

**DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE